CLAIMS

What is claimed is:

1. An extrusion blow molded container comprising:

a closed base including a support portion that supports the container upon a surface and a substantially flat elevated portion having a center and a major diameter, the center being disposed an elevated distance above said surface;

a body portion that extends from the base and is substantially free of striations; and

an open neck portion extending from the body portion;

wherein the container is comprised of polyethylene terephthalate and the elevated distance is less than about 0.05 the major diameter.

2. A container as recited in claim 1, wherein the closed base is substantially round, oval, square, or rectangular.

3. A container as recited in claim 1, including a handle.

4. A container as recited in claim 1, wherein the polyethylene terephthalate has an intrinsic viscosity that is at least about 0.96.

5. A container as recited in claim 1, wherein the container is at least partially comprised of recycled polyethylene terephthalate.

6. A container as recited in claim 1, wherein the elevated distance is at least about 0.25 inches.

7. A container as recited in claim 6, wherein the elevated distance is less than or equal to about 0.50 inches.

8. A container as recited in claim 1, wherein the base includes a contact area having a plan view area, the elevated portion comprises an elevated portion plan view area, and the bottom plan view area of the contact area has an area that is less than about 0.70 the bottom plan view area of the elevated portion.

9. A container as recited in claim 1, wherein the body portion includes vents.

10. A container as recited in claim 1, wherein the base includes a ridge.

11. A container as recited in claim 10, wherein the ridge is positioned adjacent the body portion.

12. A method for extrusion blow molding a container that is comprised of polyethylene terephthalate and has a surface finish substantially free of striations, comprising:

providing an extruder;

providing a mold set configured to form a container having a base, a body portion extending from the base, and an open neck portion extending from the body portion; the mold set having a fine-glass-bead surface finish;

extruding a hollow tube comprised of polyethylene terephthalate;

closing the mold set around the hollow tube;

injecting a gas into the hollow tube to form the container; and

opening the mold set and removing or releasing the hollow blow molded container therefrom.

13. A method as recited in claim 12, wherein the polyethylene terephthalate has an intrinsic viscosity greater than about 0.96.

14. A method as recited in claim 12, wherein the mold set includes at least one pinch-off.

15. A method as recited in claim 14, wherein the pinch-off is comprised of a metal.

16. A method as recited in claim 15, wherein the pinch-off is comprised of stainless steel.

17. A method as recited in claim 14 wherein at least one pinch-off is raised.

18. A method as recited in claim 17, wherein said at least one pinch-off includes a raised, sharp point.

19. A method as recited in claim 17, wherein raised pinches are included at least at the handle eye, tail flash, and the outer side of the handle positions.

20. A method as recited in claim 12, including the step of spin-trimming the open neck of the container.

21. A method as recited in claim 12, wherein a surface of the mold set is mechanically blasted with a material.

22. A method as recited in claim 21, wherein the mold surface is blasted to produce a smooth, light glass bead finish.

23. A method as recited in claim 12, wherein the mold is configured to produce a container having a closed base with a substantially flat elevated portion.

24. A method as recited in claim 12, wherein the container has a body portion with a substantially clear surface finish.

25. A method as recited in claim 12, wherein the hollow tube includes recycled polyethylene terephthalate.

26. A method as recited in claim 12, including the step of heat setting the container.

27. A method as recited in claim 12, wherein the extruder includes a die head and the

die head includes a head tooling coating.

28. A method as recited in claim 27, wherein the die head tooling coating includes a metallic coating.

29. A method as recited in claim 14, wherein said at least one pinch-off includes one or more compression segments.

30. A method as recited in claim 12, wherein the neck portion of the mold includes a stainless steel insert.

31. A method as recited in claim 12, including the step of forming vent openings at one or more locations on the container produced.

32. A pinch-off system for a mold having mold halves and a parting line, comprising:

a raised pinch that has an upper surface that extends above the parting line and is substantially flat and substantially parallel to the parting line; and

at least one stepped compression land having an uppermost surface that is substantially parallel to the parting line and an angled segment;

wherein the compression land is configured to have an extended length and is positioned a distance below the parting line, said length and distance configured so that the compression of a material within the mold does not block the closing of the mold halves.

33. A pinch-off system as recited in claim 32, including first and second compression lands.

34. A pinch-off system as recited in claim 32, wherein the upper surface of the raised pinch is positioned at least 0.0025 above the parting line.

35. A pinch-off system as recited in claim 32, wherein the at least one compression land extended length is at least about 0.010 inches and is positioned a distance below the parting line that is at least about 0.015 inches.

36. An apparatus for extrusion blow molding a container comprised of a polyethylene terephthalate, comprising:

an extruder;

an extruder head coated with a surface coating; and

a mold set configured to form a container having a base, a body portion extending from the base, and an open neck portion extending from the body portion, wherein a mold of the mold set has a fine-glass-bead surface finish.

37. An apparatus as recited in claim 36, wherein the surface finish of the mold is at least partially sandblasted.

38. An apparatus as recited in claim 36, wherein the coating is comprised of a metallic coating.

39. An apparatus as recited in claim 36, wherein a mold of the mold set includes a parting line and a raised pinch-off.

40. An apparatus as recited in claim 39, wherein the pinch-off includes a raised surface portion that extends at least 0.0025 inches beyond the parting line of the mold set.